

# Work Order ID 57819

April 16, 2010 10:39:24 AM



Page 1

Item ID: D3909-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Lower Attach Arm

Start Date: 16/04/2010 Start Qty: 6.00

Required Date: 29/04/2010 Req'd Qty: 6.00

Reference:

*Ind 10.04.16.*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3909

B

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 3.455" LONG

*LF 10/04/19*

*6*

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA872 AND DWG

FOLIO REV: AA

DWG REV: B

*LF 10/04/19*

*6*

DEBURR

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Page 2

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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

28 10/04/19

6

0

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

MMU= 10/04/20

6

0

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: 098

0.00

CC 1-19/20 (6)

Packaging

Memo

0.00

Packaging

**Work Order ID 57819**

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Page 3

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Setup Start

Stop

Start Date: 16/04/2010 Start Qty: 6.00

Required Date: 29/04/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/2010

MF  
10-4-20

# Picklist Print

April 16, 2010 10:39:23 AM

Page 1

Work Order ID: 57819

Parent Item: D3909-3

Parent Item Name: Fwd Lower Attach Arm

Comments: IPP REV:A NEW ISSUE 09-11-26 JLM VERIFIED BY:DD IPP  
Rev:B chg blank size in seq 100 DD 10.02.10 verified by:JLM

Start Date: 16/04/2010

Required Date: 29/04/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303B0.750X1.500		Purchased	No			100	f	8.2000	2.1051			



303 BAR .750" X 1.500"

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT53

113310

8.2

8.2

2.1051

8.8 10/04/19

DART AEROSPACE LTD		Work Order: 57819
Description: fwd X-TUBE Lug Assy		Part Number: D3909-3
Inspection Dwg: D3909	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

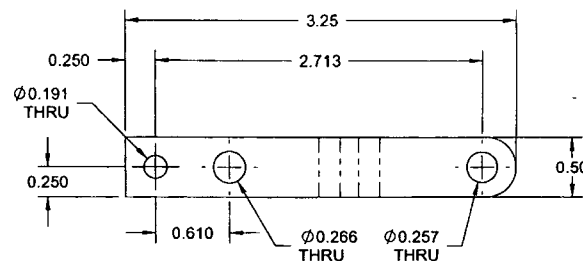
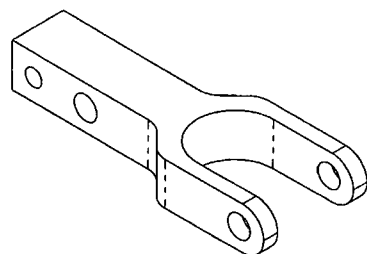
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.25	±.030	3.254	✓			
.30	"	.302	✓			
.60	"	.604	✓			
1.70	"	N/A				
2.00	"	N/A				
.38	"	.382	✓			
1.20	"	1.206	✓			
1.37	"	1.374	✓			
.16	"	.161	✓			
.610	±.070	.608	✓			
.250	"	.249	✓			
.250	"	.251	✓			
2.713	"	2.714	✓			
.50	±.030	.496	✓			
R.25		.25	✓			
R.44		.44	✓			
135°	Ref	135°	✓			
Ø.191	+ .005 - .001	.191	✓			
Ø.266	+ .006 - .001	.266	✓			
Ø.257	+ .006 - .001	.257	✓			

Measured by: L.P.	Audited by: MW	Prototype Approval:	N/A
Date: 10/04/19	Date: 10/04/20	Date:	N/A

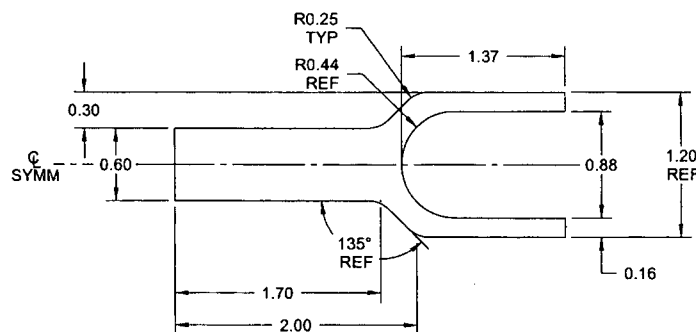
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

# 5S basics

- **Sort (Seiri) (整理):** Sorting. Refers to the practice of going through all the tools, materials, etc., in the work area and keeping only essential items. Everything else is stored or discarded. This leads to fewer hazards and less clutter to interfere with productive work.
- **Set in order (Seiton) (整頓):** Simplifying. Focuses on the need for an orderly workplace. "Orderly" in this sense means arranging the tools and equipment in an order that promotes work flow. Tools and equipment should be kept where they will be used, and the process should be ordered in a manner that eliminates extra motion.
- **Shine (Seisō) (清掃):** Sweeping, Systematic Cleaning, or Shining. Indicates the need to keep the workplace clean as well as neat. At the end of each shift, the work area is cleaned up and everything is restored to its place. The key point is that maintaining cleanliness should be part of the daily work - not an occasional activity initiated when things get too messy.



*w/o 57819*



**D3909-3 FWD LOWER ATTACH ARM**

**RELEASED**  
2010-04-07  
*MP*

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3909	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	NTS
DATE	10.04.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	